

Date: Thursday, 8/23/2007 11:50:34 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 34221		
Estimate Number	: 12840		
P.O. Number	: <u>N/A</u>	Part Number	: D35421
This Issue	: 8/23/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D3542 REV A
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 32606	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 9/3/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	<u>30</u> Um: Each
Comment	: Est Rev: A New Issue 07-04-23 JLM		
	: Est Rev: B updated powder coat per NCR 07.05.16 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"
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Comment: Qty.: 0.3500 f(s)/Unit Total: 6.9993 f(s)

6061-T6 Bar 3" x 1.5"

BATCH:

x 4" long Jul 07-12-03

M/6530

J.L 07/12/03

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A

2-Deburr per dwg D3443

OK 07/12/05 (30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

OK 07/12/05 (30)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

OK 07-12-05 (30)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MJ 07-12-06 (30)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/21/07

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:50:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34221

Part Number: D35421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105642



(30x)

Comment: POWDER COATING

Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*****ENSURE TO MASK INSIDE BORE*****

M.L. 07/12/06

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-06

(30x)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 243A

07/12/07 (30)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

08/12/07

Job Completion



08/12/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

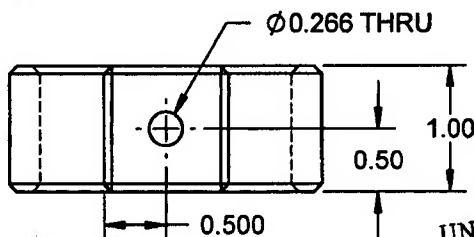
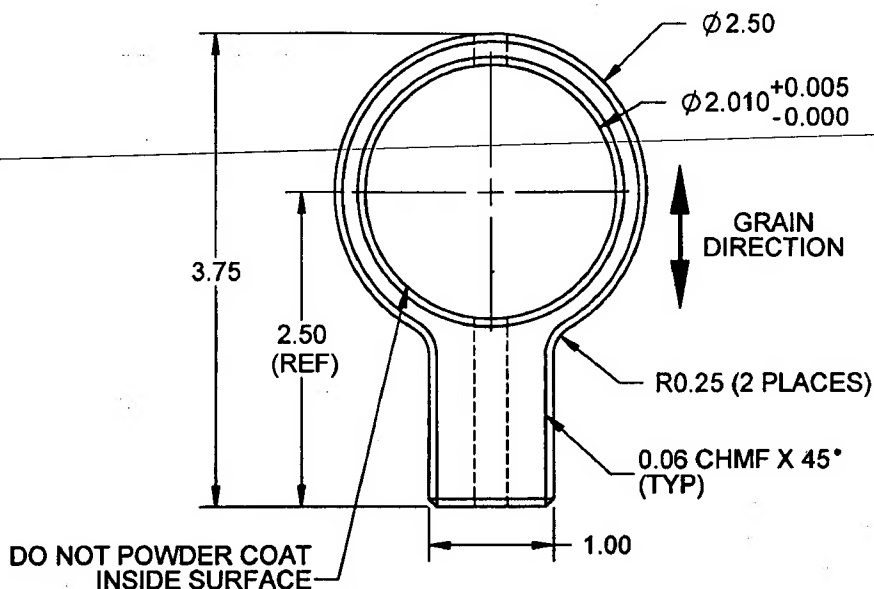
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>A</i>	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.27		TITLE BRACKET	SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

RELEASED
07.04.02



D3542-1 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34221



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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